

Work Order ID 59453

Friday, June 04, 2010 11:26:17 AM



Page 1

Item ID: D3908-3

Accept



Setup Start



Revision ID:

Item Name: Stud Receiver, Lower

Stop



Start Date: 6/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *11*Date: *10-6-04* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*28 10/06/14**8 0*

Jeaspa Bandsaw

CUT BLANK 4.00" LONG

110

0.00



HAAS 1

Memo

0.00

*28 10/06/15**8 0*

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA866 AND DWG

FOLIO REV: *AA*DWG REV: *C*

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

*ent 10/06/15*80

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

*M.A 10/06/16*80

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: *95*

0.00



Packaging

Memo

0.00

Packaging

10-0 175 88

W/O:		WORK ORDER CHANGES					
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Work Order ID 59453

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Page 3

Item ID: D3908-3

Accept



Setup Start



Revision ID:

Item Name: Stud Receiver, Lower

Stop



Start Date: 6/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21 *[Signature]*
MF
10-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 11:26:22 AM

Page 1

Work Order ID: 59453



Parent Item: D3908-3



Parent Item Name: Stud Receiver, Lower

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP REV:A NEW ISSUE 09-11-24 JLM VERIFIED BY:DD IPP Rev:B
as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C per ECN10-
581 10.05.28 DD verf:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M303B1.000X2.000		Purchased	No			100	f	0.0000	0.333333	2.807015			
303 BAR 1" X 2"													

2.6666' ¹/₁₀₀ of 4114899 SP 10/06/14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Stud Receiver Lower		Part Number:	D3908-3
Inspection Dwg: D3908	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.005/-0.001	Ø.250	/			
0.625	+/-0.010	.626	/			
0.368	+/-0.010	.364	/			
Ø0.453	+0.010/-0.000	Ø.454	/			
1.95	+/-0.030	1.940	/			
Ø0.38	+0.006/-0.001	Ø.379	/			
0.63	+/-0.030	.624	/			
2.43	+/-0.030	2.424	/			
0.63	+/-0.030	.624	/			
0.75	+/-0.030	.750	/			
0.38	+/-0.030	.375	/			
R0.06	+/-0.030	R.060	/			
R0.25	+/-0.030	R.250	/			
3.80	+/-0.030	3.800	/			
0.735	+0.000/-0.010	.733	/			
Ø0.129	+0.005/-0.001	Ø.129	/			
1.25	+/-0.030	1.250	/			
15°	+/-0.5°	15°	/			
1.587	+/-0.010	1.586	/			
1.588	+/-0.010	1.587	/			
0.31	+/-0.030	.312	/			
0.750	+/-0.010	.751	/			
0.95	+/-0.030	.948	/			
0.99	+/-0.030	.990	/			
90°	+/-0.5°	90°	/			
0.06 x 45°	+/-0.030 x 0.5°	.060 x 45°	/			
0.80	+/-0.030	.899	/			

Measured by: <i>mf</i>	Audited by: <i>H.A</i>	Preliminary Approval:
Date: 10/06/15	Date: 10/06/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

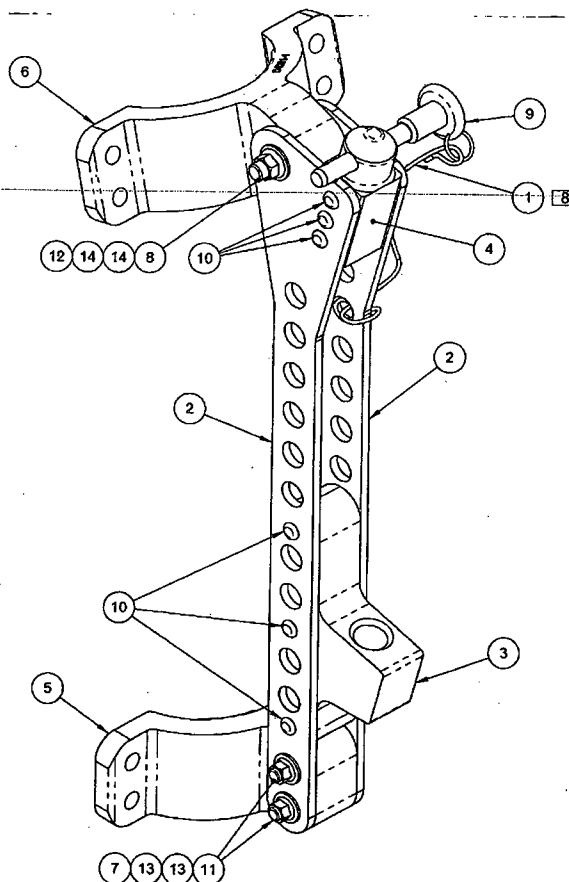
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NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 59453
RS10-6-04

RELEASED
 2010-05-28
W

C	REDESIGNED ITEM #2; ITEM#8 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3908		REV. C	
TITLE X-TUBE LUG ASSY (AFT)		SHEET 1 OF 5	
		SCALE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

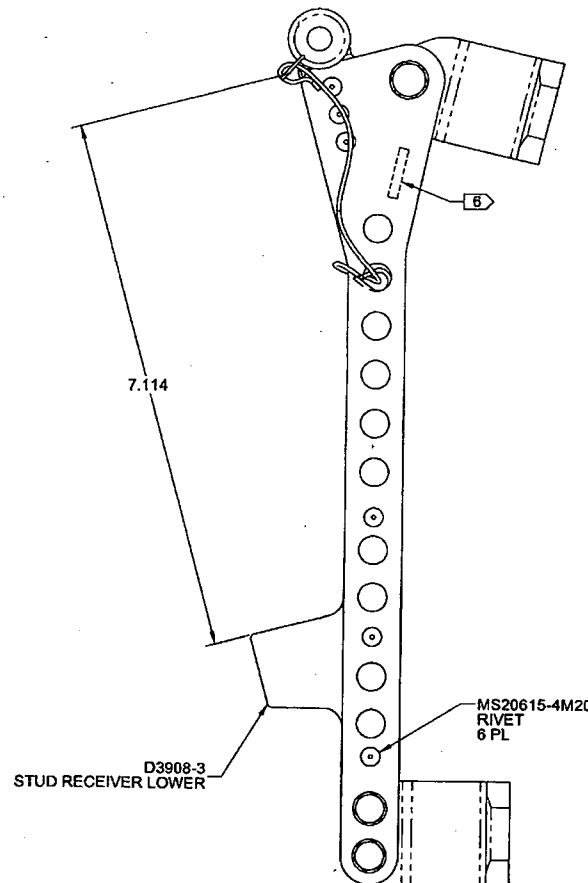
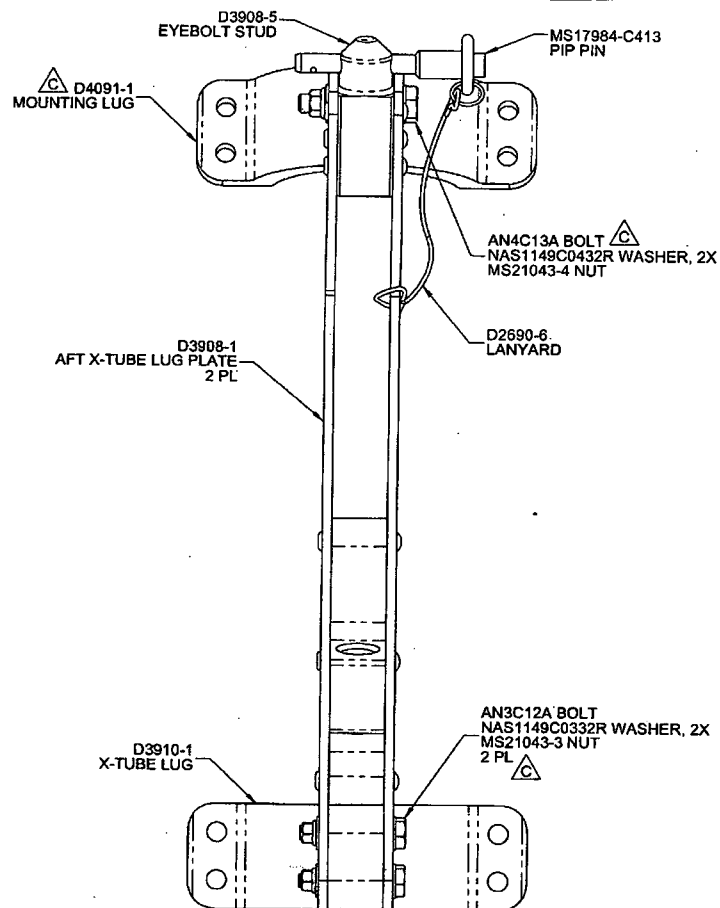
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



w/o 59453

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2010-05-28
JMD

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3908	REV. C
CHECKED			SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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DATE	10.05.27		

8 7 6 5 4 3 2 1

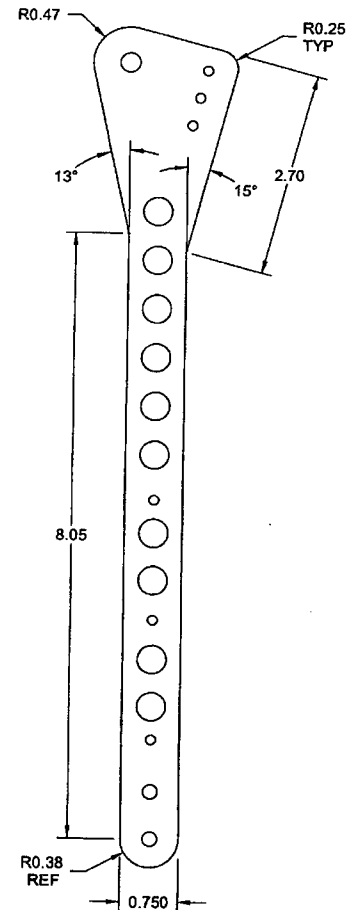
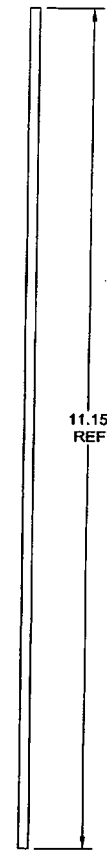
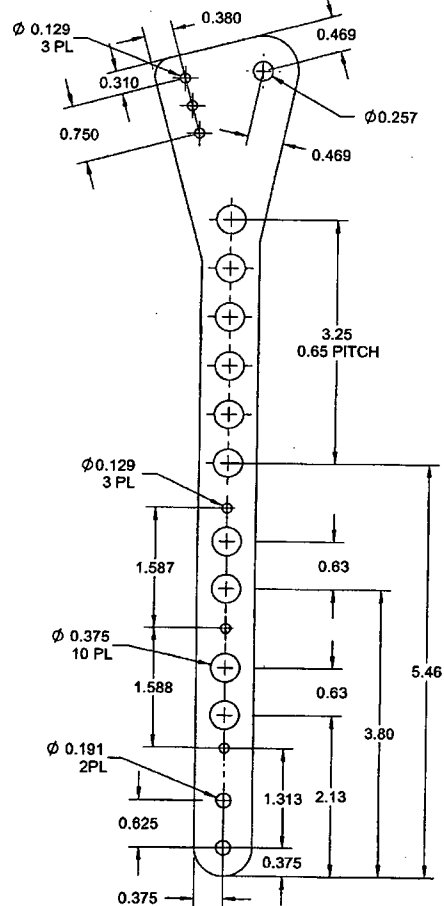
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/o 59453

RELEASED
2010-05-28
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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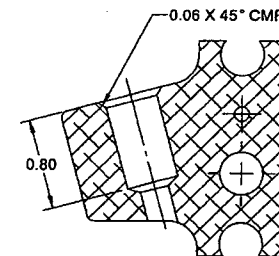
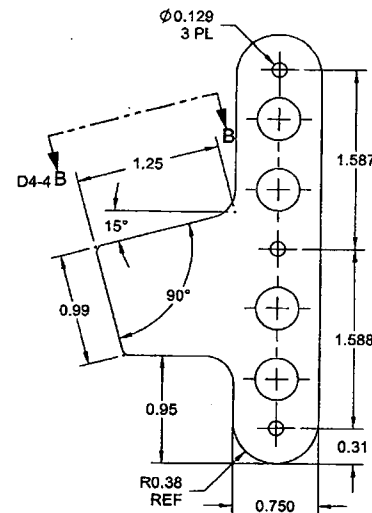
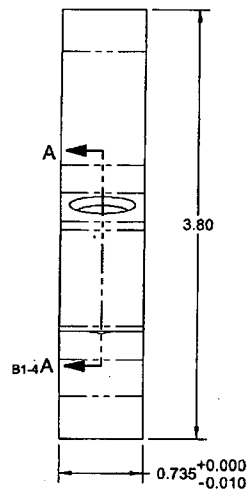
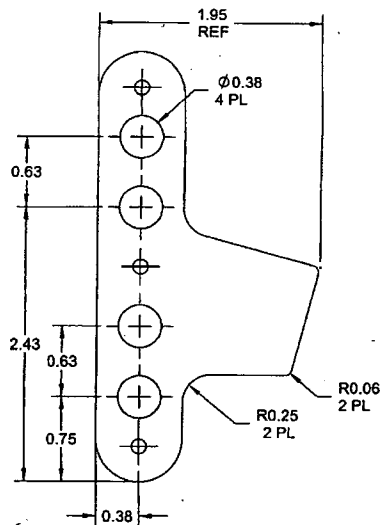
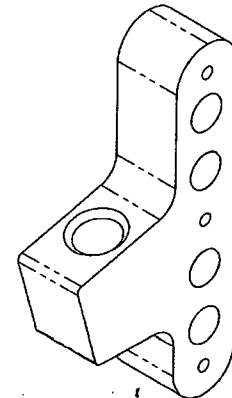
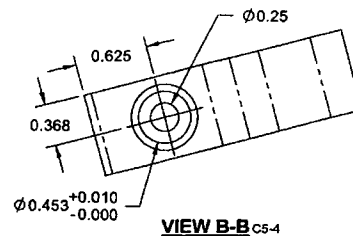
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

RELEASED
2010-05-28

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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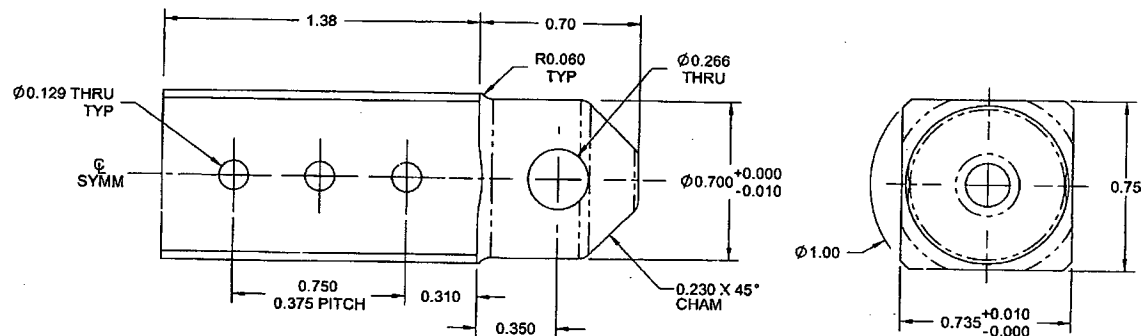
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3908-5 EYEBOLT STUD

W/0 59453

RELEASED
2010-05-28
MJP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 5 OF 5
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